

Work Order ID 59250

Friday, May 28, 2010 9:08:09 AM



Page 1

Item ID: D3417-5

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 5/28/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3417

Rev E

100

0.00



Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA761

Rev: AA &

Dwg D3417 Rev: D

2-Deburr

SL 10/05/31

50

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/05/31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 10/05/31

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3417-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 5/28/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>36</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

6/10/6/410/06/0110-6-01
50

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Picklist Print

Friday, May 28, 2010 9:08:13 AM

Page 1

Work Order ID: 59250



Parent Item: D3417-5



Parent Item Name: Washer

Start Date: 5/28/2010

Required Date: 6/4/2010

Comments: IPP Rev:A ☐ New issue ☐ 08-07-09 JLM Verified By:EC

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No			110	f	35.6000	0.0296	1.557895			



DELRIN ROUND BAR 1.25"

Location

Loc Qty

Loc Code

MAT

35.6

114586

19.6

114733

16

1.9 JL 10/05/31

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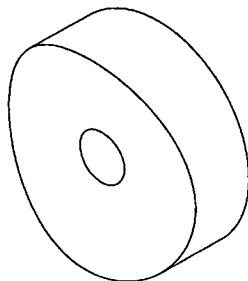
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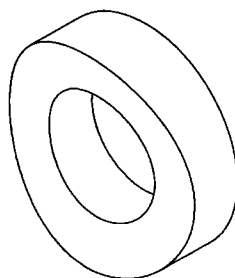
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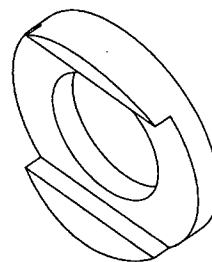
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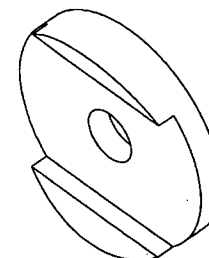
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

RELEASED
06/15/02

NOTES:

1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D3417-1, 0.02 lbs

D3417-3, 0.01 lbs

D3417-5, 0.01 lbs

D3417-7, 0.01 lbs

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT.

WITHOUT NOTICE

WORK ORDER

NO. 59250

BS10-5-21

E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS. REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D3417	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WASHER	NTS
DATE	09.06.30	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

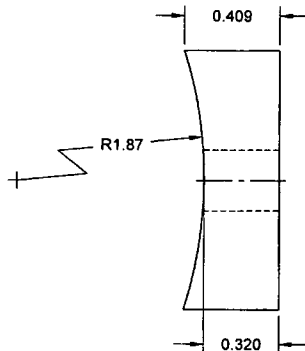
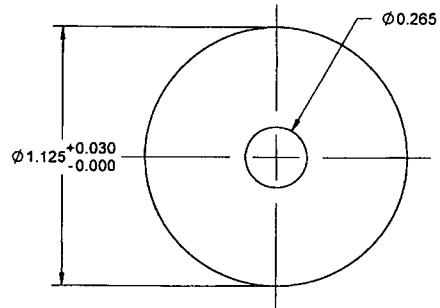
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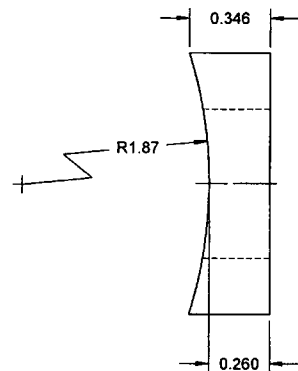
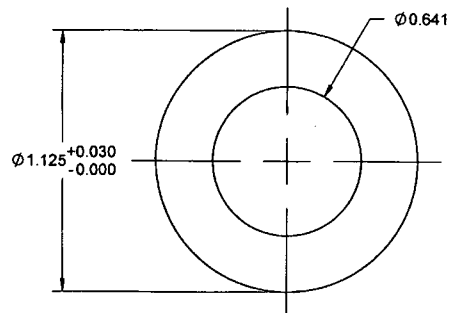
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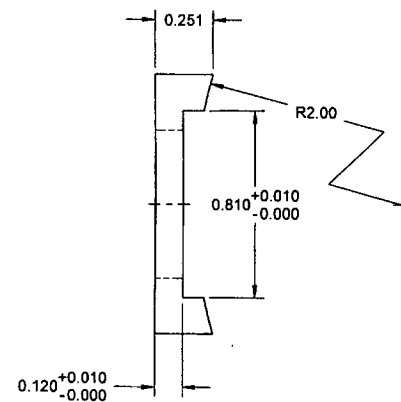
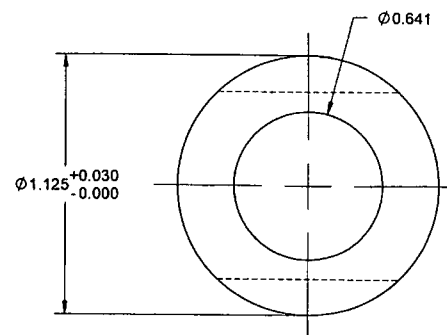
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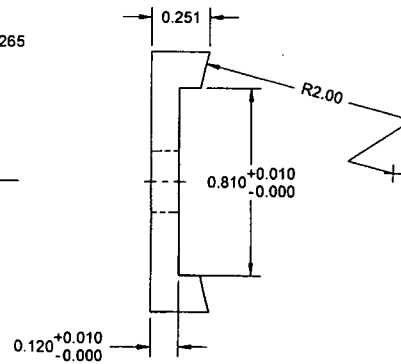
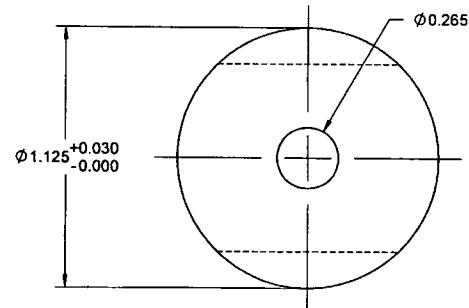
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

w/ 59250

RELEASED
01/15/10

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3417	REV. D
MFG. APPR.	<i>[Signature]</i>	TITLE WASHER	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	DATE 09.06.30	COPYRIGHT © 2005 BY DART AEROSPACE LTD
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